

Date: Friday, 01/08/2008 3:32:25 PM  
 User: Julie Lecocq

## Process Sheet

ASAP

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRONT INBOARD LEG  
 Job Number : 40972  
 Estimate Number : 13375  
 P.O. Number :  
 This Issue : 01/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D37681  
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3768 REVA  
 Previous Run : 40312 Drawing Revision : A  
 Written By : Due Date : 21/08/2008 Qty: 20 Um: Each  
 Checked & Approved By : JUL 08.8.05  
 Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T1000W065 6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 0.8969 f(s)/Unit Total: 17.9382 f(s)  
 6061T6 TUBE (1.00" x 0.65" wall)  
 batch: M108819

RG 08/08/06

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA766 Rev: A & Dwg D3768 Rev: A

2-Deburr per dwg D3768

RG 08/08/06

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RG 08/08/06 20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28 08/08/06 (20)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

08-08-07

R20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 3:32:25 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT INBOARD LEG

Job Number: 40972

Part Number: D37681

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



M180 S2



(20x)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30  
320 °F  
11:30

M.P. 08/08/07

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-07

(20x)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



(20x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

118

8/8/7

SD

9.0 QC21 FINAL INSPECTION/W/O RELEASE



(20x)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/08

Job Completion



MF 08-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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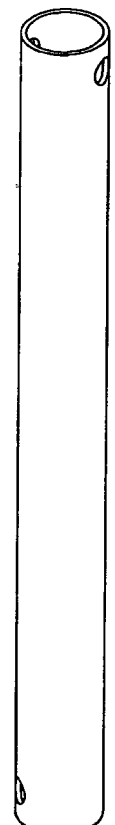
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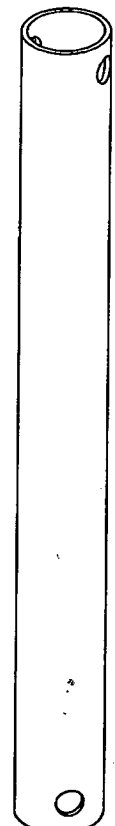
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**D3768-1 FRONT INBOARD LEG**



**D3768-3 FRONT OUTBOARD LEG, LH**



**D3768-4 FRONT OUTBOARD LEG, RH**

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.19 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
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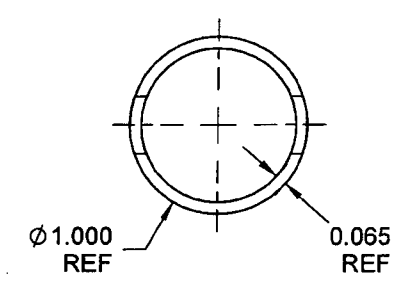
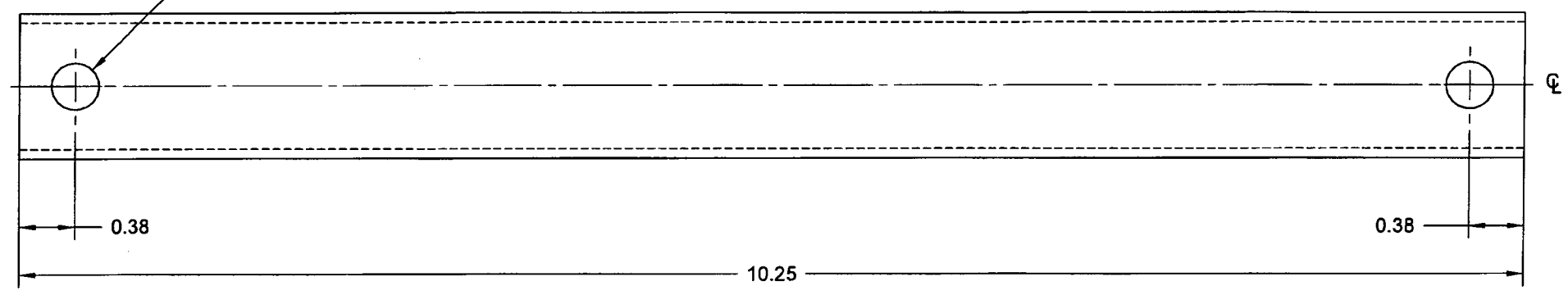
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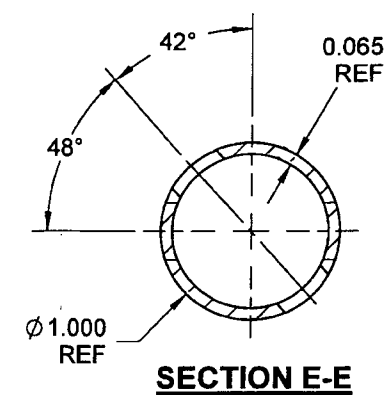
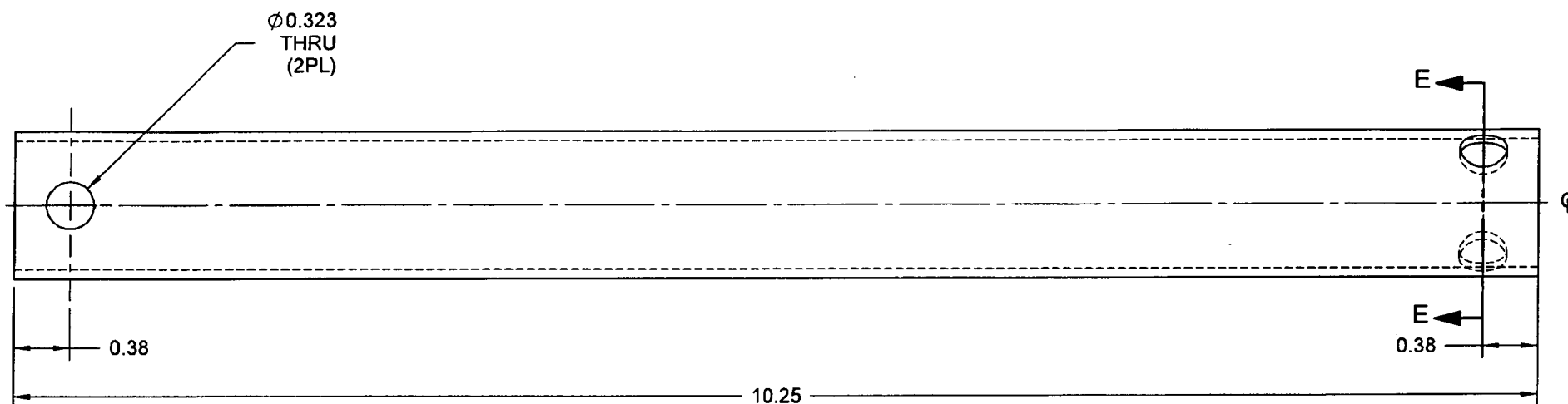
**D3768-1 FRONT INBOARD LEG**

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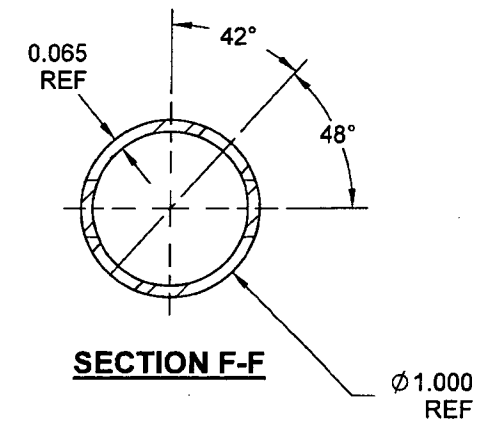
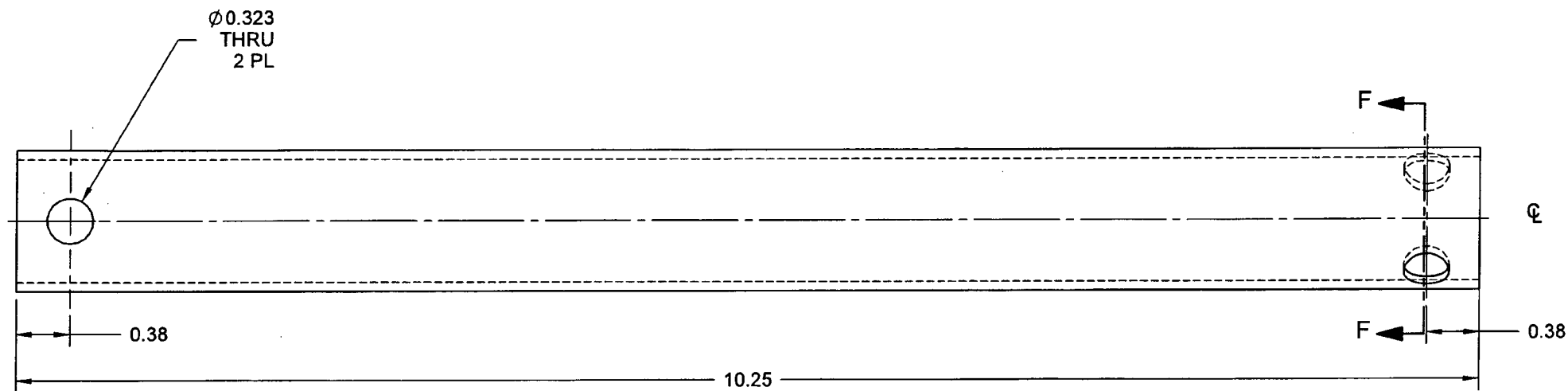


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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b>		<b>Part Number:</b>	
<b>Inspection Dwg:</b>	<b>Rev:</b>		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**[illegible]

Measured by: <i>RG</i>	Audited by: <i>SP</i>	Prototype Approval:
Date: <i>05/08/06</i>	Date: <i>08/08/06</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	